

Work Order ID 144327

Tuesday, April 12, 2016 2:36:32 PM

144327

Page 1

Item ID: D3767-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Rail
 Start Date: 4/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/19/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 16-4-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3767	Rev B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Cut tube to lenght as per dwg D3767								
	2- Drill holes thru to finish size as per dwg D3767 Using DT9410,Locate tube on stop labelled #2 and then drill holes labelled #2								
	3- Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	FF		APR 18 2016
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00			DAS 30 9-89	1			APR 18 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00			DAS 30 9-89	1			APR 18 2016

DQA: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MCJ APR 18 2016

MCJ APR 18 2016

DQA: _____ Date: _____

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Picklist Print

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Page 1
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Work Order ID: 144327

144327

Parent Item: D3767-1

D3767-1

Parent Item Name: Upper Rail

Start Date: 4/12/2016

Required Date: 4/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added drilling tooling 08-08-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased				100	f	151.2524	2.7917	2.938632			

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

FF APR 14 2016

Location	Loc Qty	Loc Code
GA002	122.634927	
M126183	0.17416	
M132597	2.365877	
M133700	12.09489	
M134504	48	
M134528	60	
MAT	28.617432	
M132577	28.617432	

~~2.938632~~
2.938632

DQA: _____ Date: _____

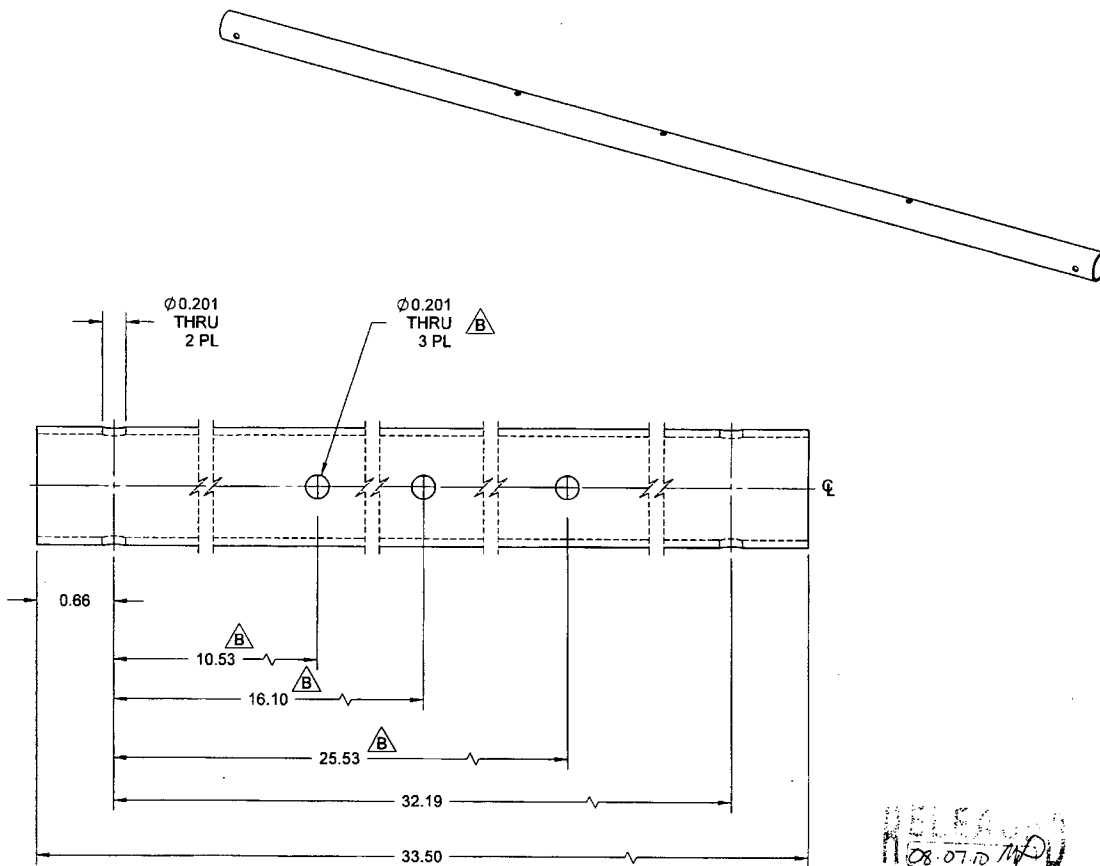
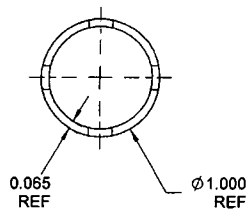


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OTHER : ☐																																																															



D3767-1 UPPER RAIL

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

B	CHANGE HOLE SIZE TO 0.201, SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3767 REV. B SHEET 1 OF 1 TITLE UPPER RAIL SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.23		